

Work Order ID 77826

December-21-11 3:42:01 PM

77826

Page 1

Item ID: D3255-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Access Panel Assembly

Start Date: 21/12/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: M.C.D

Date: 11/12/22 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3255

Rev B

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per Dwg D3255 ***purge weld***A/R SS ROD
Batch: 2EE5117 2-Grind Welds Flush

110

0.00

110

QC

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

Quality Control

120

0.00

120

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

11-12-29 (2k)

8 11/12/29

8 11/12/29

(72)

7041

Work Order ID 77826

77826

Page 2

December-21-11 3:42:01 PM

Item ID: D3255-041 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Access Panel Assembly
 Start Date: 21/12/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 05/01/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
130									
Powdercoat		0.00							
Powder Coating									
	Memo								
	START TIME: 11:00								
	FINISH TIME: 11:30								
140	QC3- Inspect Part Finish	0.00							
140									
QC		0.00							
Quality Control									
	Memo								
150		0.00							
150									
Small Fab		0.00							
Small Fab									
	Memo								
	1-Bond D3255-5 gasaket to d3255-041 using Dow corning adhesive as per Dwg								
	D3255A/R 736 DOW CORNING ADHESIVE								
	Batch: 116664								

2x M-12/04/02

12 01 03 (2)

12 01 03 (2)

December-21-11 3:42:01 PM

Page 3

MF
12-01-04

Picklist Print

Page 1

December-21-11 3:42:04 PM

Work Order ID: 77826

77826

Parent Item: D3255-041

D3255-041

Parent Item Name: Access Panel Assembly

Start Date: 21/12/2011

Required Date: 05/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3255-1

Manufactured

No

100

Each

8.0000

1

4

D3255-1

Panel

**

B75968 → 2x DJ 11/12/28

Location

Loc Qty

Loc Code

WA025

8

72191

2

75968

6

D3255-5

Manufactured

No

100

Each

7.0000

1

4

D3255-5

Gasket

**

Location

Loc Qty

Loc Code

GA

7

72118

1

75083

6

D3255-3

Manufactured

No

150

Each

29.0000

1

4

D3255-3

Cap

**

B75969 → 2x DJ 11/12/28

Location

Loc Qty

Loc Code

WA022

29

72152

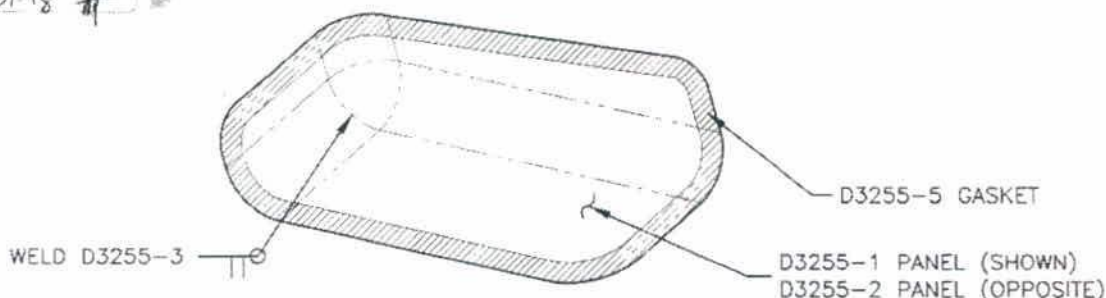
4

75969

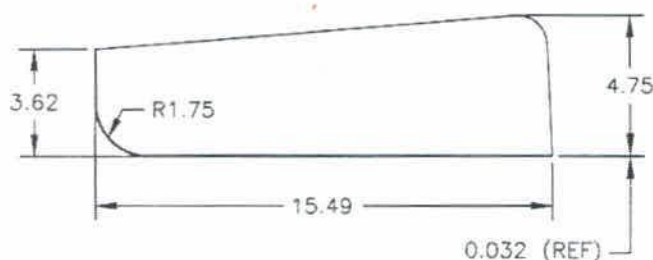
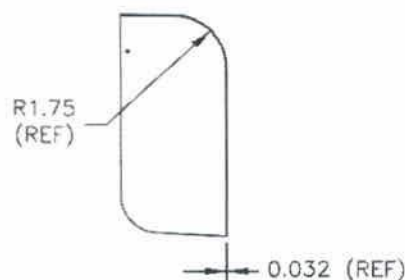
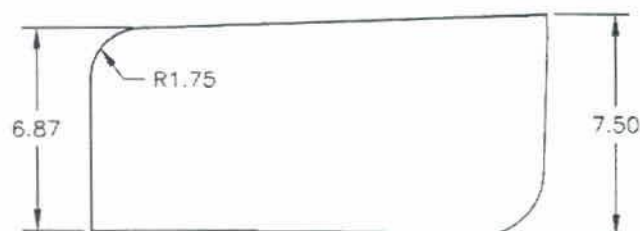
25



RELEASED
05-01-18



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

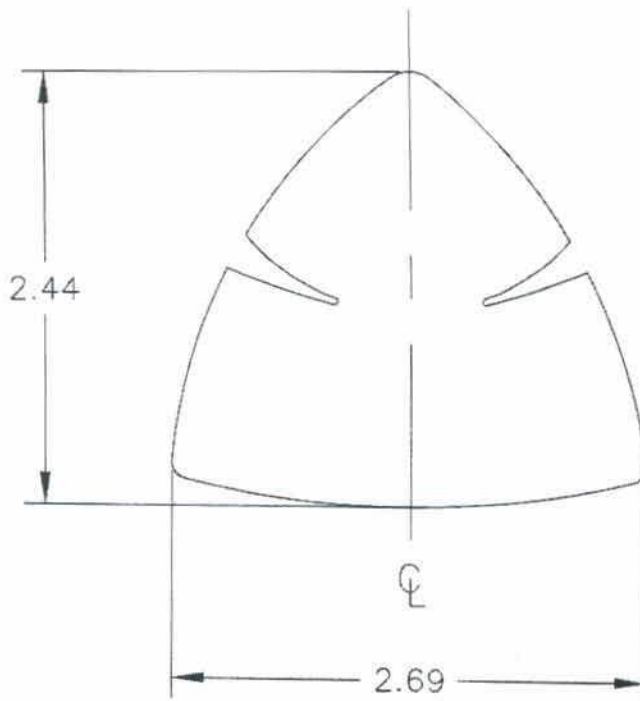
INFORMATION
FOR THE
INFORMATION COPY
SUBJECT TO DISCUSSION
WITH THE BOARD
WELLS FARGO
INC. 77826 H.C.S
11/12/22

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05 01 18 [Signature]

D3255-3 CAP
FORM TO FIT D3155-1/-2

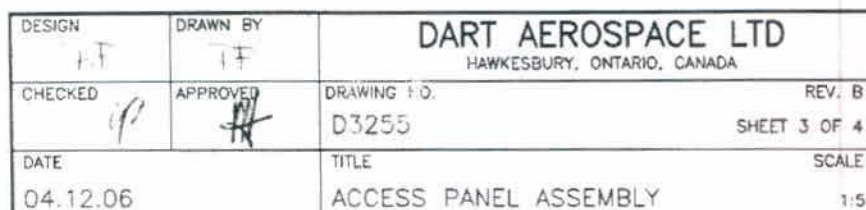
D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

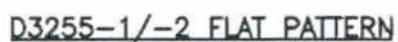
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

02844



RELEASED
05 01 18



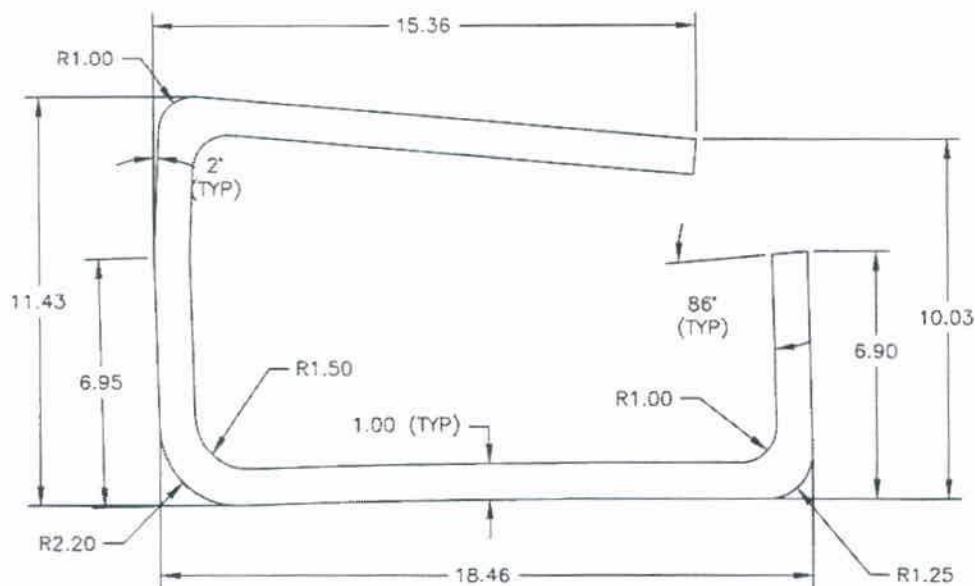
1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

928th



DESIGN 17	DRAWN BY 17	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05 01 18 [Signature]



D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

92826